

Tuesday, March 31, 2015 9:57:35 AM

131231

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Tail Rotor Pedal Lock

Start Date: 3/31/15 **Start Qty:** 3.00 ***3***

Cust Item ID:

Required Date: 4/03/15 **Req'd Qty:** 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan:  Date: 5/3/91 Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3371	Rev B

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT!- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.

2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer.

Discard the rest.

3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5

4- Assemble lock mechanism and cam and install decal as per Dwg D3371.

Apply locktite to lock body nut.

Qty	Part Number	Description
A/R		262 Locktite

Batch
M125715

130

0.00

130

Small Fab

Small Fab

Memo

00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 131231

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131231

Page 3

Item ID: D3371-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tail Rotor Pedal Lock
Start Date: 3/31/15 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 4/03/15 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

ML5 1504-15MF
15-4 14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 131231

131231

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 3/31/15

Required Date: 4/03/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 *238-028* 3/16" Dowel Pin .5" long		Purchased	No			120	Each	16.0000	2	6		APR 13 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST568	106673	16				1			
				108114		16				5			
AN526C832R6 *AN526C832R6* Screw		Purchased	No			120	Each	88.0000	4	12		APR 13 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		88				12			
				m131379		88							
D2728-7 *D2728-7* Dart Logo Label		Manufactured	No			120	Each	0.0000	0	0		APR 13 2015	
D3371-1 *D3371-1* Pedal Lock Base		Manufactured	No			120	Each	6.0000	1	3		APR 13 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST498	109066 *	6				1			
				106255		2				1			
				109067		2				1			
				70040		2							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Page 2

Work Order ID: 131231

131231

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 3/31/15

Required Date: 4/03/15

Start Qty: 3.00

Required Qty: 3.00

D3371-3 Manufactured No

120 Each 10.0000 1 3

D3371-3

Pedal Lock Cover

**

FF

APR 13 2015

Location

Loc Qty

Loc Code

ST498

10

104353

10

3

D3373-7 Manufactured No

120 Each 15.0000 1 3

D3373-7

Cam Lock

**

FF

APR 13 2015

Location

Loc Qty

Loc Code

ST036

15

123528

4

94791

11

3

D3385-3 Manufactured No

120 Each 34.0000 1 3

D3385-3

Hinge

**

FF

APR 13 2015

Location

Loc Qty

Loc Code

ST036

34

117534

34

3

CBL-1240 Purchased No

130 f 197.3270 1.6666 6

CBL-1240

Cable

**

FF

APR 13 2015

Location

Loc Qty

Loc Code

GA

197.327

m130006

197.327

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Material									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 131231

131231

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 3/31/15

Required Date: 4/03/15

Start Qty: 3.00

Required Qty: 3.00

CBL-460	Purchased	No	130	Each	500.0000	2	6		
CBI -460								**	FF APR 13 2015
Loop Sleeve									

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			GA	500					
			m131619	500			6		
D3384-1	Manufactured	No		130	Each	6.0000	1	3	
D3384-1								**	FF APR 13 2015
Cyclic Sock									

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST500	6					
			123313	6			3		
HX-81	Purchased	No		140	Each	78.0000	1	3	
HX-81								**	FF APR 13 2015
1/4"-20 SHCS 3/8" long									

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST554	78					
			123436	78			3		
NAS1149F0463P	Purchased	No		140	Each	1,309.000	2	6	
NAS1149F0463P								**	FF APR 13 2015
Washer									

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST260a	986	
	m127832	986	
	st268	323	
	m127832	315	
	m130388	8	

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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